

Work Order ID 50319

July 14, 2009 12:01:12 PM



Page 1

Item ID: D3151-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: BRACKET

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: mf Date: 09-07-15

Tooling:

Date:

Stop



QC: Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3151

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3151 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

FB 9-8-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FB 9-8-13

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 508/08/13

KS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 50319

Page 3

July 14, 2009 12:01:12 PM

Item ID: D3151-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: BRACKET

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>68</u> Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

9.00 09-08 14 (8)

9/8/14 (8x) 54

09/08/25 74

W 9.08.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 12:01:11 PM

Work Order ID: 50319



Parent Item: D3151-3RevC



Parent Item Name: BRACKET

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	77.9100	105.2632	8		PTO



2024-T3 .040 sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	77.91	
110337	6.4	
111381	4	
111786	67.51	

111786

B 9-8-13

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.08.24		correct sf on Bom				07.08.24	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 50319
Description: Doubler Assembly		Part Number: D3151-3
Inspection Dwg: D3151	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	✓			
Ø0.250	+0.005/-0.001	.252	✓			
Ø0.700	+0.008/-0.001	.701	✓			
2.75	+/-0.030	2.784	✗			
6.76	+/-0.030	6.761	✗			
6.060	+/-0.010	6.068	✗			
1.075	+/-0.010	1.076	✗			
3.305	+/-0.010	3.307	✗			
0.350	+/-0.010	.351	✗			
0.688	+/-0.010	.686	✗			
0.344	+/-0.010	.343	✗			
1.480	+/-0.010	1.480	✗			
2.150	+/-0.010	2.148	✗			
3.800	+/-0.010	3.800	✗			
1.975	+/-0.010	1.974	✗			
0.350	+/-0.010	.351	✓			
0.475	+/-0.010	.477	✓			
1.800	+/-0.010	1.798	✗			
2.050	+/-0.010	2.048	✓			
1.375	+/-0.010	1.375	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-8-13	Date: 09/08/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.20	New Issue	KJ/DD	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3151	REV. C SHEET 1 OF 1
DATE 05.12.07		TITLE DOUBLER ASSEMBLY	SCALE 1:4
A	02.04.23	NEW ISSUE	
B	04.09.08	RE-DESIGN	
C	05.12.07	REVISE NOTES	

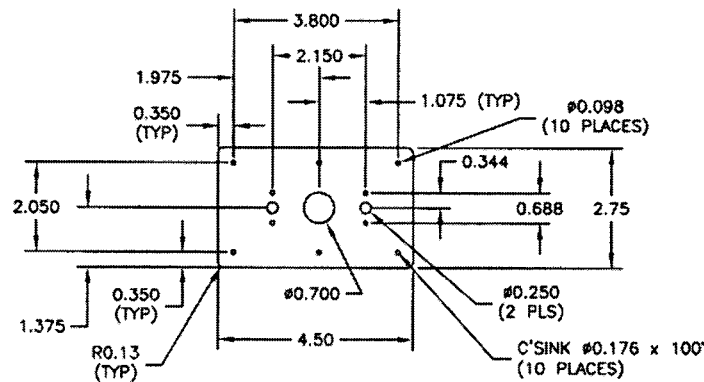
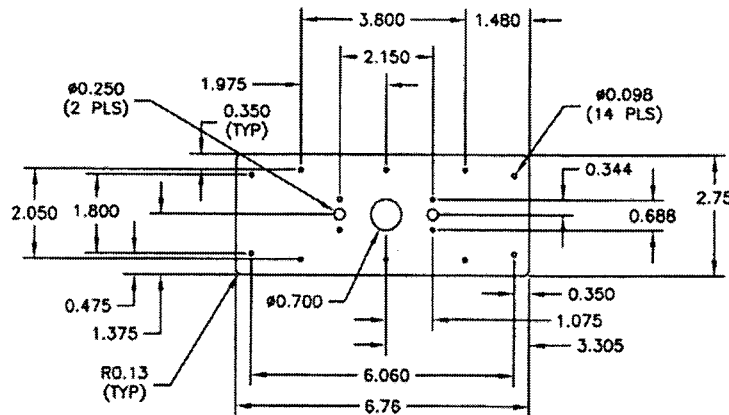
MS20426AD3-3 RIVET (1)
(6 PLACES)MS21059L08 NUTPLATE (1)
MS20426AD3-4 RIVET (2)
(2 PLACES)

D3151-3

D3151-1

D3151-041 DOUBLER ASSEMBLY
REPLACES PREMIER P/N B30-23000-173/-174

RELEASED

05.12.07 *[Signature]***D3151-1**SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50319
MF 09-07-15**D3151-3****NOTES**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

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